

Date: Tuesday, 23/09/2008 10:22:25 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 42230	Part Number	: D323835
Estimate Number	: 12668	Drawing Number	: D3238 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 23/09/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: // Type : SMALL /MED FAB	Due Date	: 20/10/2008
Previous Run	: 39229	Qty:	50 Um: Each
Written By	:		
Checked & Approved By	: <u>Julie Lecocq 9.23</u>		
Comment	: Est Rev:A New Issue 07-01-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S020	6061-T6 Sheet .020
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MAT NOT PULLED



Comment: Qty.: 0 sf(s)/Unit Total : 1 sf(s)
6061-T6 .020 Sheet
Batch: 3019 B 8-9-29

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3238
Dwg Rev: C
Prog Rev: C

B 8-9-29

2-Deburr if necessary
Use cutting file D3238-21-23-25**

08/10/01 (59) Hm

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-9-29



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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M 08-10-01 / 08-10-01



(59) counted

Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M 08-10-02

(59)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 42230

Part Number: D323835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(59)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/10/02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CU 8/10/02 (59)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.10.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



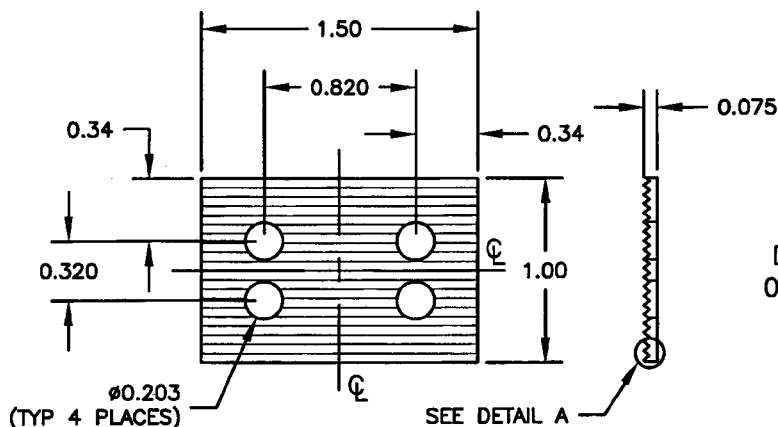
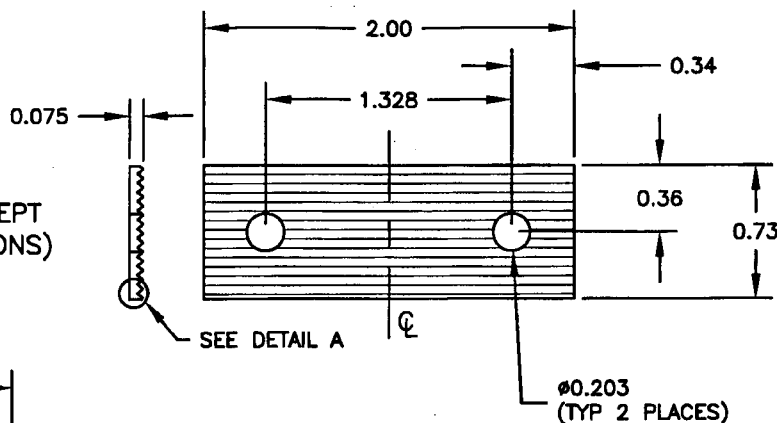
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)

D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)

D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR

ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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WITHOUT NOTICE
WORK ORDER

NO. 42330

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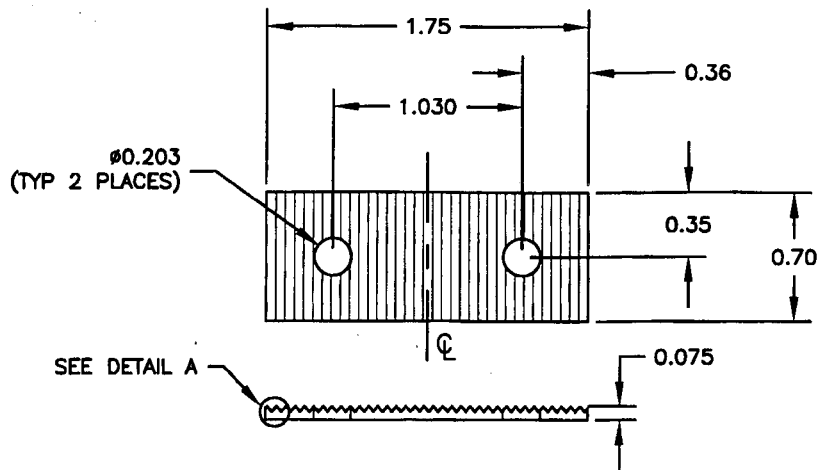
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DART

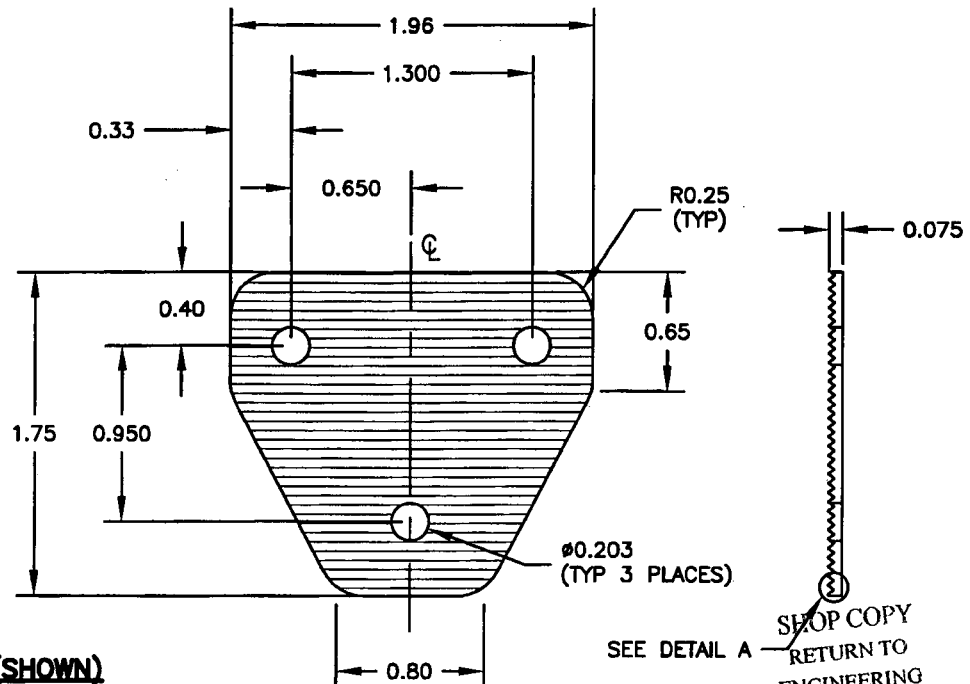
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

RELEASED

07.02.20



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

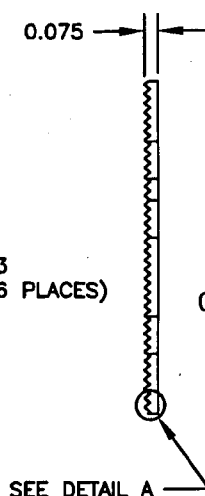
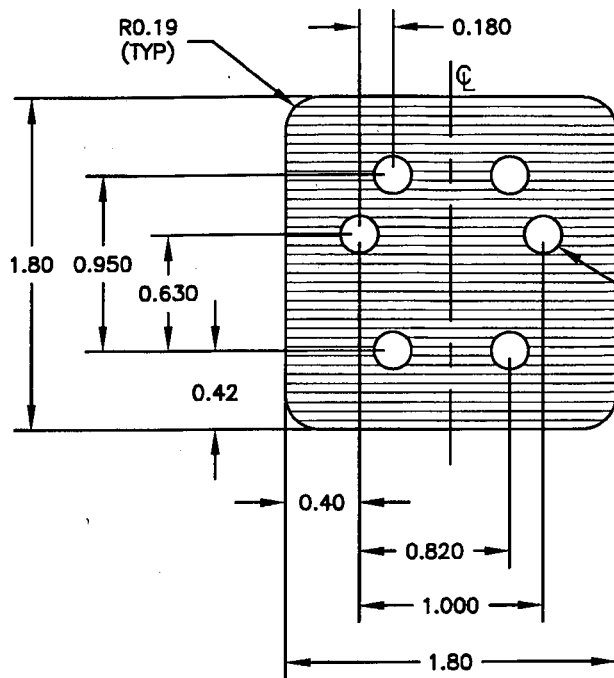
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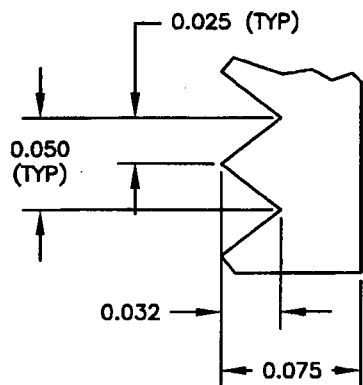


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

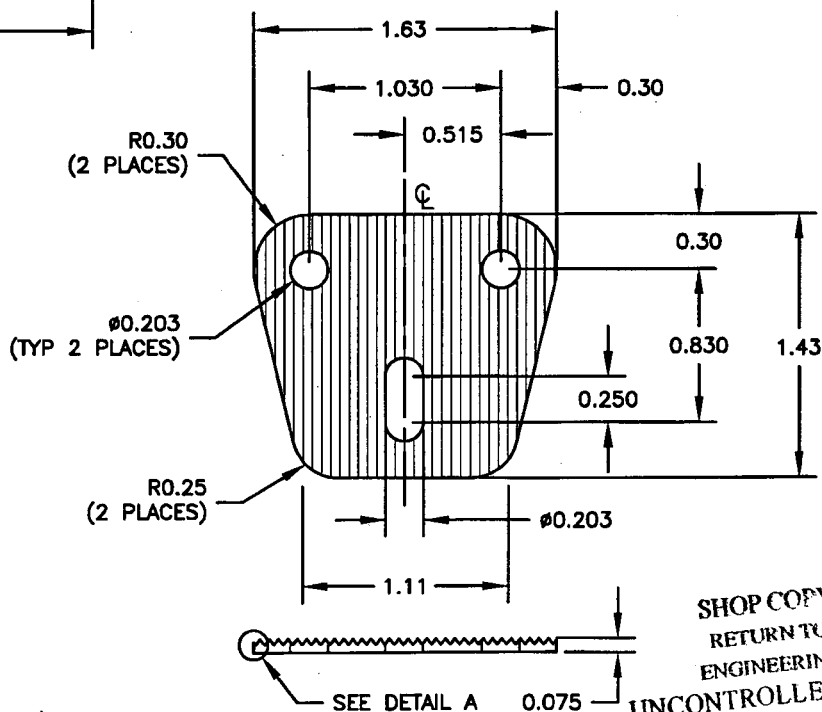


RELEASED
07.02.20 #

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS) NO. 42230

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